

Date: Friday, 26/09/2008 10:23:56 AM  
 User: Julie Lecocq

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> : VERTICAL TUNNEL LOWER                |
| <b>Job Number</b> : 42295                               |  |
| <b>Estimate Number</b> : 13603                          |  |
| <b>P.O. Number</b> :                                    | <b>Part Number</b> : D38227                                |
| <b>This Issue</b> : 26/09/2008 <b>S.O. No.</b> :        | <b>Drawing Number</b> : D38227 PROTOTYPE                   |
| <b>Prsht Rev.</b> : NC                                  | <b>Project Number</b> :                                    |
| <b>First Issue</b> : // <b>Type</b> : R&D THERMOFORMING | <b>Drawing Revision</b> : PROTOTYPE                        |
| <b>Previous Run</b> :                                   | <b>Material</b> : KYDEX 6185 (TBD)                         |
| <b>Written By</b> :                                     | <b>Due Date</b> : 17/10/2008 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JUL 08.09.26</u>  |  |
| <b>Comment</b> : Est. Rev. A New Issue 08.09.25 DL      |  |

## Additional Product

SCRAP

PROTOTYPE

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |                |                              |
|-----|----------------|------------------------------|
| 1.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

JL 08.09.26

|     |                |                              |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

JL 08.09.26

|     |               |                       |
|-----|---------------|-----------------------|
| 3.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-7 and folio (FTA 9396 Prototype) using tool DT 9396

Dwg. Rev. PROTOTYPEFolio Rev. A-

JL 08.09.26

(X1)

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

JL 08.09.26

(X1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL LOWER

Job Number: 42295

Part Number: D38227

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



08.09.26



Comment: SECOND CHECK

|     |                |                              |
|-----|----------------|------------------------------|
| 6.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08.09.26 x1

|     |     |  |
|-----|-----|--|
| 7.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



x1

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

08.09.26

|     |     |                              |
|-----|-----|------------------------------|
| 8.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



08.09.26



Comment: INSPECT WORK TO CURRENT STEP

|     |             |                       |
|-----|-------------|-----------------------|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

|      |      |                              |
|------|------|------------------------------|
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.12.16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries